



Dart Aerospace Ltd.  
1270 Aberdeen St  
Hawkesbury, ON  
K6A 1K7  
Canada

Tel (613) 632-5200

**D2374**

**Job Sheet 169879**



Part No: **D2374**

Job Qty: **12 ea**

Part Name: Stud



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/3/18

Job Tracking No:

Due Date: 1/12/18

Created By: Mario Poulin

Type: Stock

Description:

Customer: Access Helicopters (CACCE02)

102-6305 Airport Way Kelowna, BC, V1V 1S1 Canada ph:(403) 755-1791 fx:(403) 755-1936.

Note: DWG REV A IPP D 03.04.04 Reformat; Made on Cobra KJ/RF IPP Rev:E Now on Doosan Lathe 08-05-05  
JLM Verified By:EC

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty    | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |              | Sign-off                 |
|-------|--------------------|--------|------------|----------|-----------|---------|-----------------------|--------------|--------------------------|
|       |                    |        |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time    |                          |
| 90    | Start up Operation | 12 Ea  | 1/11/18    | 1/11/18  | 0.00      | 0.00    | Start Up Machining    |              | <i>M.P. 18/02/23</i>     |
| 100   | Doosan             | 12 pcs | 1/12/18    | 1/12/18  | 0.07      | 1.98    | Doosan                |              | <i>M.P. 18/02/23</i>     |
| 120   | QC                 | 12 pcs | 1/12/18    | 1/12/18  | 0.00      | 0.00    | QC8                   |              | <i>Reginald 18/02/25</i> |
| 130   | Packaging          | 12 pcs | 1/12/18    | 1/12/18  | 0.00      | 0.00    | Packaging3            | <i>Stock</i> | <b>FEB 27 2018</b>       |
| 140   | QC21-SA            | 12 Ea  | 1/12/18    | 1/12/18  | 0.00      | 0.00    | QC21                  |              |                          |

Part Op 100 - 1- Turn as per Folio FA156 Rev: \_\_\_\_\_ & Dwg D2374 Rev: \_\_\_\_\_ 2- Mill as per Folio FA156 Rev: \_\_\_\_\_ & Dwg  
Descriptions: D2374 Rev: \_\_\_\_\_ 3-Deburr per dwg D2374

**DAS**  
**21**  
**3-00**

**FEB 27 2018**

### Job Allocations

| Operation             | Component Part        | Required | Inventory | Allocated | Std Qty |
|-----------------------|-----------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | <b>MDELRRINR1.000</b> | 2        | 4         | 0         | 0       |

### Part Specifications

| Spec No | Description | Target/Tolerance               | Limits                         | Type     | Special Comments |
|---------|-------------|--------------------------------|--------------------------------|----------|------------------|
| 1       | Stud        | 1.000Inches ± 0.010            | <i>1.000</i><br>1.010<br>0.990 |          |                  |
| 2       | Stud        | 0.625Inches ± 0.010            | <i>0.625</i><br>0.635<br>0.615 |          |                  |
| 3       | Stud        | 0.500Inches + 0.005<br>- 0.000 | <i>0.500</i><br>0.505<br>0.500 | Diameter |                  |
| 4       | Stud        | 0.313Inches + 0.005<br>- 0.000 | <i>0.314</i><br>0.318<br>0.313 | Diameter |                  |
| 5       | Stud        | 0.062Inches ± 0.010            | <i>0.062</i><br>0.072<br>0.052 | Radius   |                  |
| 6       | Stud        | 0.300Inches ± 0.010            | <i>0.300</i><br>0.310<br>0.290 |          |                  |
| 7       | Stud        | 1.313Inches ± 0.010            | <i>1.311</i><br>1.323<br>1.303 |          |                  |
| 8       | Stud        | 0.125Inches ± 0.010            | <i>0.127</i><br>0.135<br>0.115 |          |                  |
| 9       | Stud        | 0.772Inches ± 0.010            | <i>0.769</i><br>0.782          |          |                  |

|    |      |                     |        |
|----|------|---------------------|--------|
| 10 | Stud | 0.563Inches ± 0.010 | 0.762  |
|    |      | 0.573               | Radius |
|    |      | 0.563               | 0.553  |

Plex 1/3/18 8:12 AM dart.poulin.mario



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Container No: S044872



Part: D2374

Job No: 169879

Serial No/Batch: S044872

Revision: D2374

Inspector:

Date: 02/23/18